

# Work Order ID 51790

September 3, 2009 8:47:14 AM



Page 1

Item ID: D3506-3	Accept		Setup Start	
Revision ID: A			Stop	
Item Name: Doubler				
Start Date: 04/09/2009	Start Qty: 40.00		Cust Item ID:	
Required Date: 15/09/2009	Req'd Qty: 40.00		Customer:	
Reference:	<i>09.09.03</i>			
Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:
			Run Start	
			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3506	Rev A						98		
100	FLOW WATER JET	0.00							
	Waterjet								
	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3506 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2- Deburr if necessary								
									(98)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									
120	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA640 and Dwg D3506								

RB 99-3

RB 99-3

98 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3506-3 PAR #: \_\_\_\_\_ Fault Category: Procd. Machineel parts NCR: (Yes) No DQA: / Date: 05.05.16  
 Resolution: SCVAP Disposition: SCVAP QA: N/C Closed: / Date: 05.05.16

NCR: <u>51790</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/09/04</u>	<u>120</u>	<u>Place is too thin because it move in machining app</u>  <u>R.C. Process</u>	<u>/</u> <u>05/08/04</u>	<u>Qty 1 scrap. No replace.</u>	<u>mF</u> <u>09/09/04</u>	<u>B.A</u> <u>09/09/04</u>	<u>/</u> <u>05/08/04</u>	<u>/</u> <u>05/08/04</u>

NOTE: Date & initial all entries

# Work Order ID 51790

September 3, 2009 8:47:14 AM



Page 2

Item ID: D3506-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 04/09/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 15/09/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

MF  
09/09/04

97 1

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

L.A 09/09/04

97 1

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

C'sink as per Dwg D3506(On Flat side)

EB 09/09/04  
97

M.H 09/08/03  
Grind off pin

**Work Order ID 51790**

September 3, 2009 8:47:14 AM



Page 3

Item ID: D3506-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 04/09/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 15/09/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

=&gt; 8/01/02/09

QC

Memo

0.00

counter  
(X97)

φ

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

BR 0909-9

(97)

HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00

=&gt; 8/01/02/09

QC

Memo

0.00

counter  
(X97)

φ

Quality Control

**Work Order ID 51790**

September 3, 2009 8:47:14 AM



Page 4

Item ID: D3506-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 04/09/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 15/09/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: 104

0.00



Packaging

Memo

0.00

Packaging

09/09/10 (97)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/10 MF 09-09-10

# Picklist Print

September 3, 2009 8:47:13 AM

Page 1

Work Order ID: 51790

Parent Item: D3506-3RevA

Parent Item Name: Doubler



Comments:

Start Date: 04/09/2009

Required Date: 15/09/2009

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.100 		Purchased	No			120	sf	64.1716	0.3284	.8045		
6061-T6 .100 Sheet												

IB 9-9-3

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

102201

64.17157902

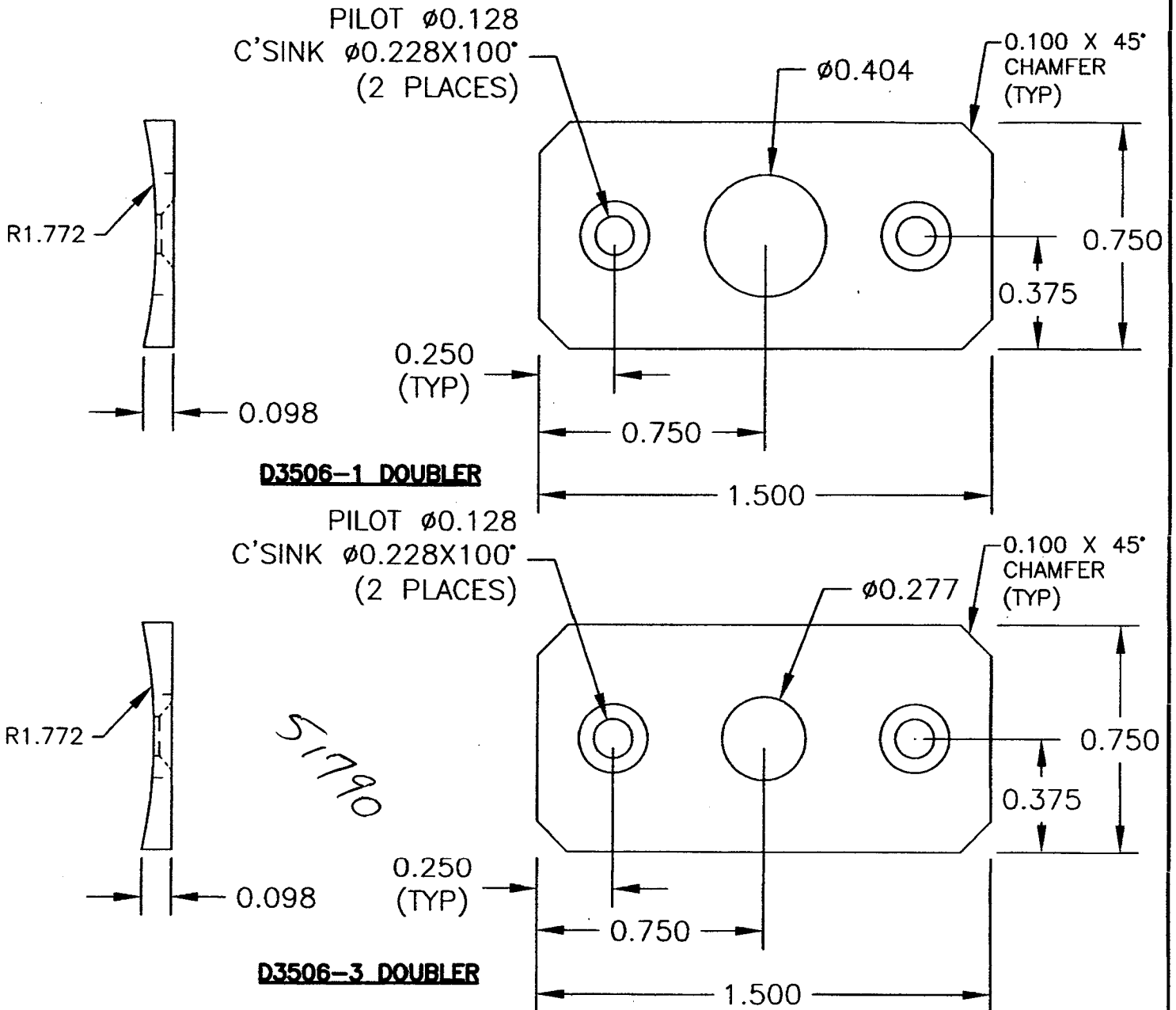
64.1715790

102201



**DART**

DESIGN 94	DRAWN BY 94	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 94	APPROVED 94	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)  
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**  
06.10.03 PM  
per ECN #861

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.